

Work Order ID 51328

August 19, 2009 10:49:55 AM



Page 1

Item ID: D2917-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle RH

Start Date: 08/19/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: *mmf*

Date: *09-08-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2917

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number ☐ Machine Step No 1 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 2 as per Folio FA439 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 3 as per Folio

mmf 09/09/04

4 2

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

mmf 09/09/04

4 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mmf 09/09/04

4 0

FTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2917-2 PAR #: _____ Fault Category: Machined parts NCR: Yes No DQA: [Signature] Date: 05-05-10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 05-05-10

NCR: <u>51328</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/09/05</u>	<u>100</u>	<u>1 part scrap, the thickness wall are too small ϕ.090"</u> <u>R.L. operator error. take the origins at the wrong place.</u>	<u>[Signature]</u>	<u>destroy and replace Qty 1 Batch: 51423</u>	<u>amb</u> <u>09/09/08</u>	<u>N.A</u> <u>09/09/08</u>	<u>[Signature]</u> <u>05-05-08</u>	<u>[Signature]</u> <u>05-05-08</u>
<u>09.05.08</u>	<u>100</u>	<u>Saddle-to-skid holes are ϕ0.449</u>	<u>[Signature]</u> <u>09.05.08</u> <u>pu</u> <u>QSI 042</u>	<u>Fit with bushing too loose. Critical location. Scrap part.</u>	<u>mk</u> <u>09/09/08</u>	<u>N.A</u> <u>09/09/08</u>	<u>[Signature]</u> <u>09.05.08</u> <u>pu</u> <u>QSI 042</u>	<u>[Signature]</u> <u>05-05-08</u>

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M.A 09/09/04

4

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

umo 09/09/08

xy

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:30pm FINISH TIME: 4:00pm OVEN TEMPERATURE: 320°F

JH 09/09/08

4

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 3

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Setup Start



Revision ID: B

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Item Name: Saddle RH

Start Date: 08/19/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-09-9 (4)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Pc 09/9 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/09 (4)

mf 09-09-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

August 19, 2009 10:49:54 AM

Work Order ID: 51328



Parent Item: D2917-2RevB



Parent Item Name: Saddle RH

Start Date: 08/19/2009

Required Date: 08/24/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010RevD		Manufactured	No			100	Each	0.0000	4.0000			

Saddle Billet

Batch # 57423 4 mfg 08/09/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	51328
Description: Saddle RH		Part Number:	D2917-2
Inspection Dwg: D2917 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.175	0.205		.188	.189	.188	.185		
B	0.090	0.110		.105	.098	.100	.090		
C	0.250	0.270		.258	.258	.260	.256		
D	1.599	1.619		1.611	1.611	1.611	1.609		
E	0.180	0.220		.180	.180	.180	.180		
F	0.277	0.297		.282	.282	.282	.281		
G	1.385	1.400		1.387	1.390	1.390	1.387		
H	3.170	3.230		3.188	3.194	3.193	2.191		
I	0.175	0.217		.177	.181	.180	.180		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.501	1.503	1.503	1.503		
L	4.436	4.446		4.440	4.441	4.441	4.441		
M	0.257	0.262	DT8683	.259	.259	.259	.259		
N	1.225	1.235		1.232	1.229	1.229	1.229		
O	1.103	1.113		1.106	1.109	1.109	1.109		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.443	.443	.443	.443		
R	0.490	0.510		.500	.504	.500	.503		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.002	8.002	8.002	8.002		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.205	.201	.203	.201		
W	2.000	2.040		2.002	2.002	2.003	2.002		
X	0.760	0.765		.760	.760	.760	.760		
Y	0.307	0.312		.312	.311	.311	.311		
Z	0.615	0.635		.628	.630	.633	.633		
AA	0.177	0.197		.187	.187	.187	.187		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	anf
Date:	09/09/04

Audited by:	H.A
Date:	09/09/04

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM	

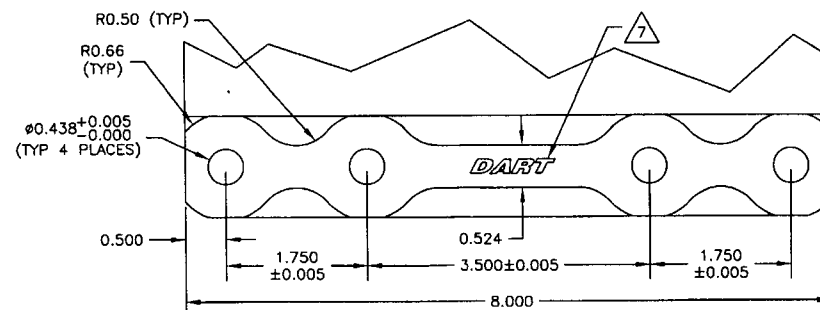
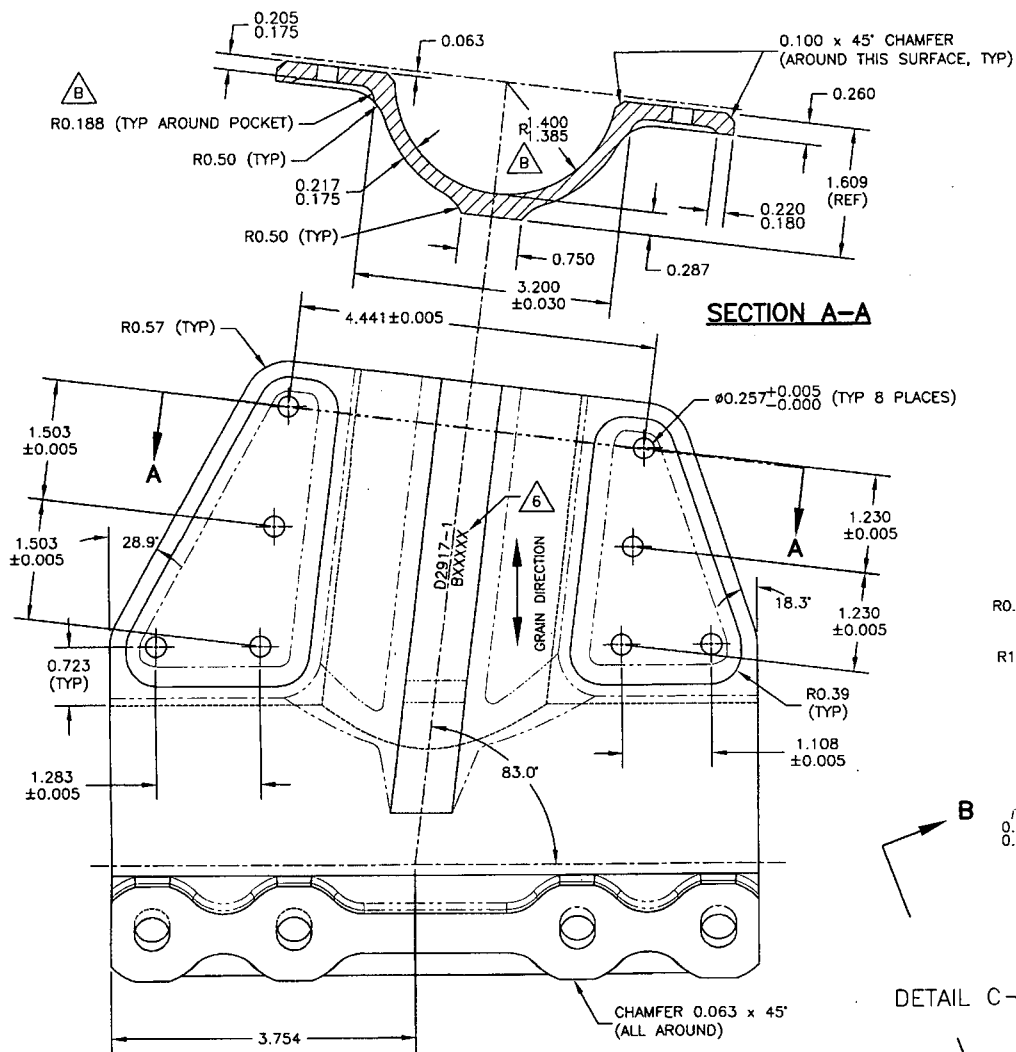
W/O:		WORK ORDER CHANGES					
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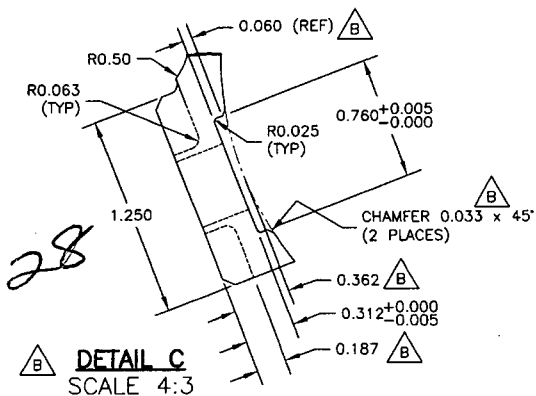
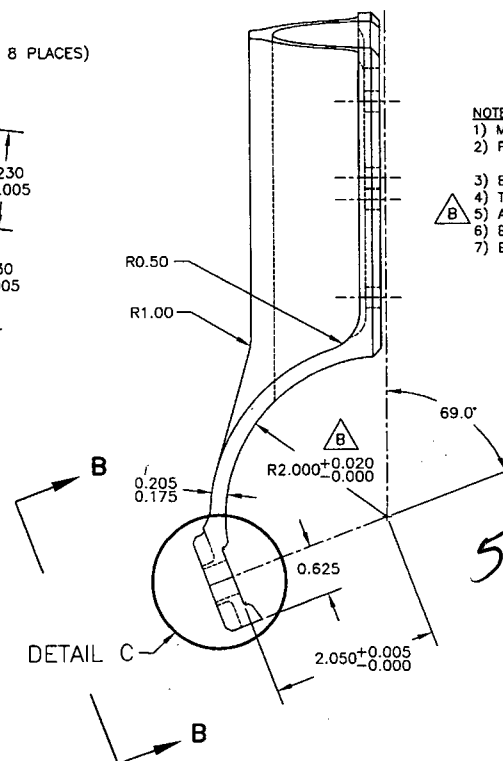
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NOTE: Date & initial all entries



D2917-1 LH SADDLE (SHOWN)
D2917-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 - 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



RELEASED

07.07.31

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 DART AEROSPACE LTD.

B	07.06.26	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	GP	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	07.06.26	TITLE
		SADDLE
		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D2917
		REV. B
		SHEET 1 OF 1
		SCALE
		2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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